

Date: Thursday, 16/08/2007 2:56:20 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 34037

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA087

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143

Inside of Cuff(Donot engrave on outside of tube)

8/07/08/22 ①

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

8/07/08/22 ①

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8-07-08-29 ①

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

JB 7-8-29

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JA08-29 ①

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 7-8-29

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-143 using CNC bender program 206L-fw and Folio FT017

EL 7-8-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 34037

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Job 30 @



Comment: DIMENSIONAL CHECK OF X-TUBES

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143 Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-143.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

7-9-4

JD 7-9-5

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 7-9-6

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

En 07/09/06

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Checked all holes En 07/09/06

W/O:		WORK ORDER CHANGES					
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Drawing Name: 206L FWD X-TUBE

Job Number: 34037

Part Number: D206667103

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 OUTSIDE SERV.10 OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES
Liquid Penetrant Inspection as per QSI 038Or
Issue P/O: 4530 LPI as per ASTM 1417
Level 2 Attach copy of NDT results to work order

W 07-09-06

18.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Inspect for transit damage
Ensure copy of NDT results attached to work order.

W 07/09/12 @

19.0 QC6 DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

W 07-09-12 @

20.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

*Issue PO 4585 W 07-09-13
Spray paint Self-Primer Blue + Clear*

21.0 QC14 INSPECT SPRAY PAINT



Comment: Inspect Spray Paint
Wrap in plastic bag to protect from scratches

W 07 09 17 @

22.0 D2856400 Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total: 1.2138 f(s)
Pick:

Qty Part number Description Batch
2 D2856-400(Cut to 6.94") Abrasion Strip

26650 W 07 09 17

20 b Receive & Inspect for transit damage 07/9/17

W/O:		WORK ORDER CHANGES					
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Job Number: 34037

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043

Nut Plate

32512

RT 07-09-13

24.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

32777

RT 07-09-13

25.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support

34147

ml 07 09 17

26.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8

Rivet

105057

RT 07-09-13

27.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

104902

ml 07 09 17

W/O:		WORK ORDER CHANGES					
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Job Number: 34037

Part Number: D206667103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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28.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. Note: (2) Aft holes should be facing up.

2-Install supports and clamps as per Dwg D4206-667-143. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

Handwritten: M
07 09 17
27 07-09-13

29.0

QC5



Handwritten: nut plates → 2708-13

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 2709-17 (2)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: *Handwritten:* M103880

Handwritten: S9

32.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: *Handwritten:* M104547

Handwritten: S9

33.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

10 AN5-7A

Bolt

Handwritten: M104603

Handwritten: 7/9/18 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☒ DQA: P Date: 07/09/15
 QA: N/C Closed: _____ Date: _____

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Drawing Name: 206L FWD X-TUBE

Job Number: 34037

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-30A

Bolt

M19522, SP

35.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

H1 18 AN960JD516 Washer M104156

7/9/18 SP

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Er 07/09/18

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103

Location:

PPP Rev:

B 10 7/9/18

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/09/19

Job Completion



U 07-09-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-143	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH FWD) NTS	
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

05-07-26

UNDER REVIEW

05.08.10 PH

re-draw detail F

Qty	Part Number	Description
X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
1	D6002-115	CROSSTUBE
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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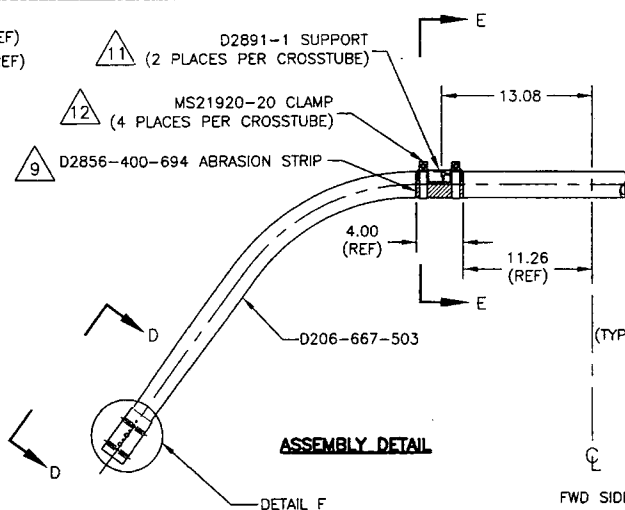
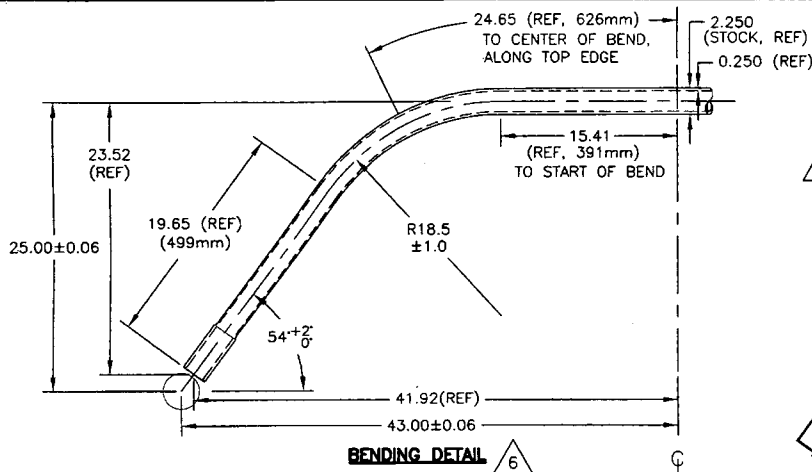
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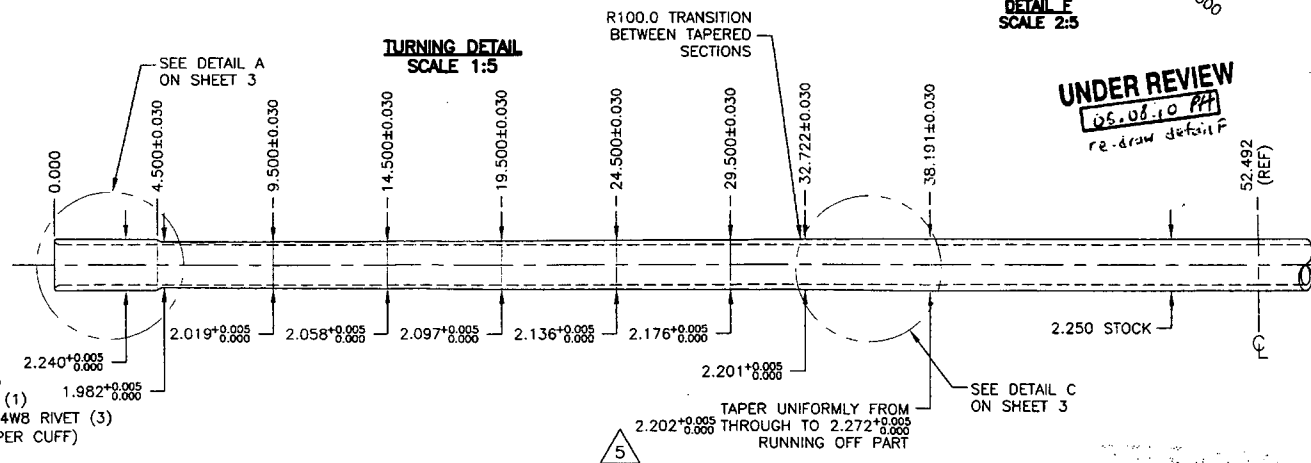
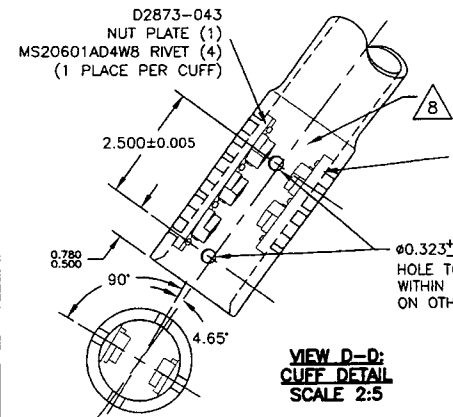
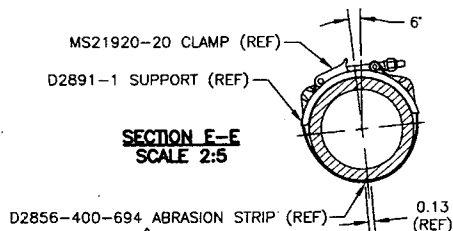
Ø0.323^{+0.005}_{-0.000} (TYP 5 PLACES PER CUFF)
HOLE TO BE ALIGNED WITHIN ±0.001 OF HOLE ON OTHER SIDE OF CUFF

PILOT Ø0.128 C'SINK Ø0.225X100 (TYP 7 PLACES PER CUFF)

FWD SIDE ONLY

DETAIL E SCALE 2:5

UNDER REVIEW
05.08.10 PH
re-draw detail F



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DESIGN PH

CHECKED DS

DATE 05.07.26

DRAWN BY PH

APPROVED DS

DART

DART AEROSPACE LTD.
WARRICKSURY, OXFORD, CANADA

DRAWING NO. D206-667-143

TITLE CROSSTUBE ASS'Y (206L HIGH FWD)

REV. B
SHEET 2 OF 3
SCALE 1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

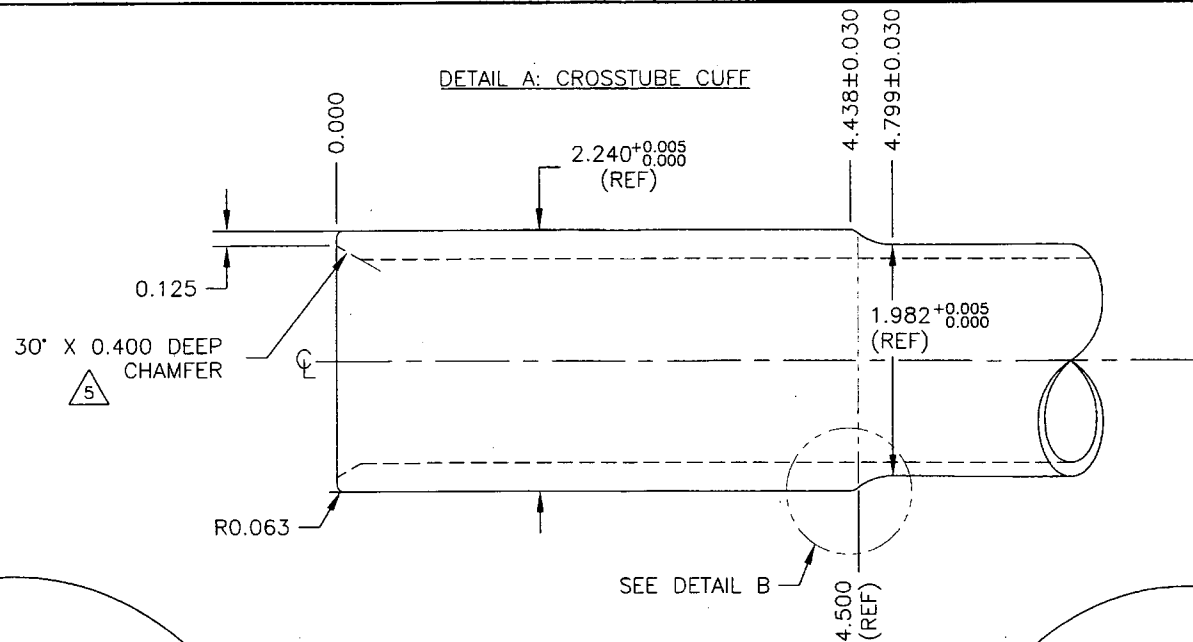
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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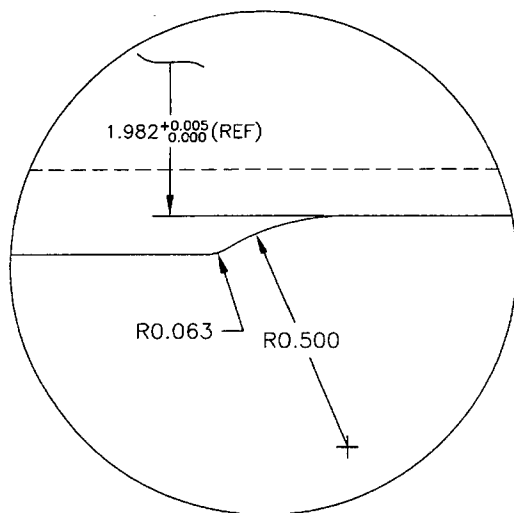
NOTE: Date & initial all entries

DETAIL A: CROSSTUBE CUFF

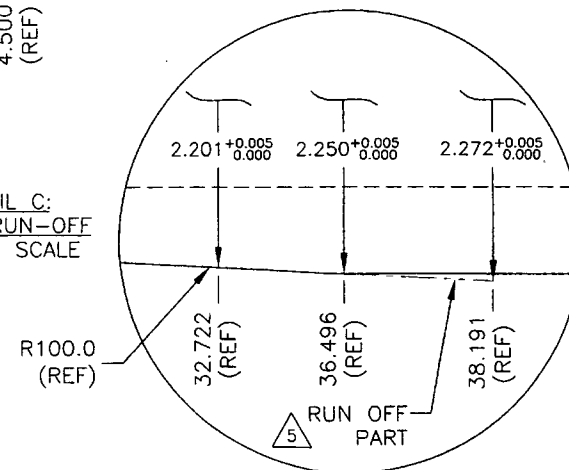


05.07.26 #

UNDER REVIEW
05.08.10 PH
re-draw detail F



DETAIL C: TAPER RUN-OFF NOT TO SCALE



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DESIGN PH

DRAWN BY PH

DART DART AEROSPACE LTD.
HARRISBURG, ONTARIO, CANADA

CHECKED #DS

APPROVED #DS

DRAWING NO.
D206-667-143

REV. B
SHEET 3 OF 3

DATE
05.07.26

TITLE
CROSSTUBE ASS'Y (206L HIGH FWD)

SCALE
1:1

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order: 34037
Description: Crosstube Assembly (206L High Fwd)	Part Number: D206-667-143
Inspection Dwg: D206-667-143 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.244				
	1.982	+0.005/-0.000	1.986				
	2.019	+0.005/-0.000	2.021				
	2.058	+0.005/-0.000	2.062				
	2.097	+0.005/-0.000	2.101				
	2.136	+0.005/-0.000	2.140				
	2.176	+0.005/-0.000	2.180				
	2.201	+0.005/-0.000	2.205				
	0.125	+/-0.010	.125				
	0.400 x 30°	+/-0.010	.400				
	R0.063	+/-0.010	.063				
	R0.500	+/-0.010	.500				
	4.438	+/-0.030	4.444				
SIDE B	104.98	+/-0.020	104.98				
	2.240	+0.005/-0.000	2.244				
	1.982	+0.005/-0.000	1.986				
	2.019	+0.005/-0.000	2.021				
	2.058	+0.005/-0.000	2.062				
	2.097	+0.005/-0.000	2.101				
	2.136	+0.005/-0.000	2.140				
	2.176	+0.005/-0.000	2.180				
	2.201	+0.005/-0.000	2.205				
	0.125	+/-0.010	.125				
	0.400 x 30°	+/-0.010	.400				
	R0.063	+/-0.010	.063				
	R0.500	+/-0.010	.500				
	4.438	+/-0.030	4.444				

Measured by: SF	Audited by: [Signature]	Prototype Approval:	N/A
Date: 02/05/21	Date: 02.08.29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.05.06	New Issue (P/O D206-667-103)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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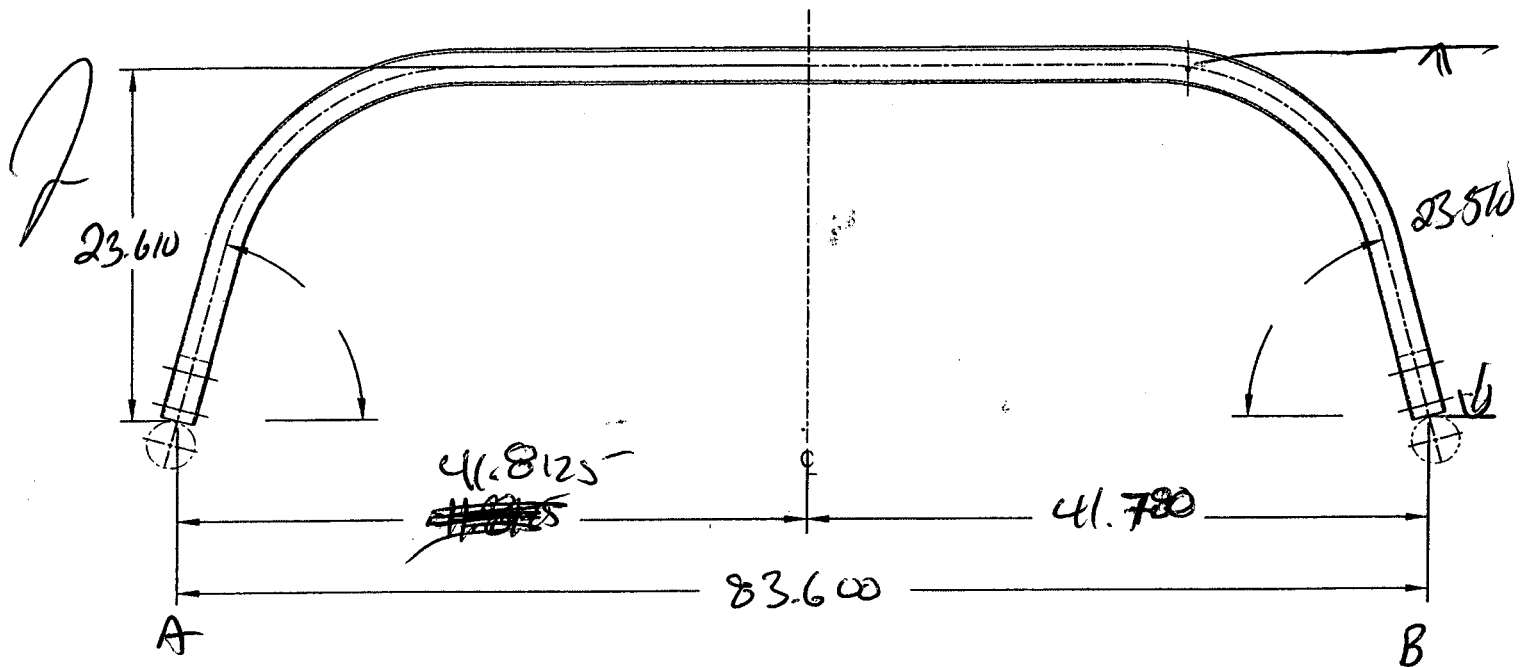
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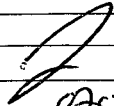
NOTE: Date & initial all entries


DART AEROSPACE LTD		Work Order:	34037
Description: Crosstube High Fwd (206L)		Part Number:	D206-667-103
Inspection Dwg: D206-667-143 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 37332

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of three (3) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI-038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (3) P/N D206-667-103 S/N's B34037, B34047 & B34046



RADIOGRAPHY



ULTRASONIC



PENETRANT



MAGNETIC PARTICLE



EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on three (3) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)

Ardrox 970P25E Batch #04B503.

Three (3) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

S. FLETCHER
S. FLETCHER

DATE September 10, 2007

INSPECTION
STAMP(S) Not Required

CUSTOMER INFORMATION

CUSTOMER Dart Aerospace

P.O. NUMBER

4530

ADDRESS:

CONTACT NAME:

LABOUR	@	\$
MATERIALS	@	
TRAVEL EXPENSES	@	GST
HOTEL EXPENSES	@	PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT